

# Work Order ID 57163

March 24, 2010 8:54:04 AM



Page 1

Item ID: D2512

Accept



Setup Start



Revision ID:

Item Name: Basket Lid 205/350

Stop



Start Date: 24/03/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 31/03/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*PL*

Date:

*10-3-24*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2512

Rev E

100

Weld per dwg A/R S.S. rod Batch: *M114645*

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

*SAD 10-08-18*

4-Weld as per Dwg D2512 using Welding Jig DT 9436

Deburr as required

\*\*\*INSTALL D2012-117 CLEVIS ONLY ON D130-701-041\*\*\*

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

*BE*  
*10-08-26*

*10/08/26 (1x)*

*1*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 57163

March 24, 2010 8:54:04 AM



Page 2

Item ID:	D2512	Accept		Setup	Start	
Revision ID:						
Item Name:	Basket Lid 205/350				Stop	
Start Date:	24/03/2010	Start Qty:	1.00			
Required Date:	31/03/2010	Req'd Qty:	1.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

120	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00	8 wlos26						
Quality Control									

130	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	Memo	0.00							
Powder Coating									

1- Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat

11/17/84  
 1ST COAT:  
 START TIME: 9:25  
 OVEN TEMPERATURE: 400°  
 FINISH TIME: 9:55  
 2ND COAT:  
 START TIME:  
 OVEN TEMPERATURE:  
 FINISH TIME:

1 BR 10-8-27

1 BR 10-8-27

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**Dart Aerospace Ltd**

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 57163**

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Accept



Setup Start



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Stop



Start Date: 24/03/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 31/03/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/30

10-8-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

March 24, 2010 8:54:09 AM

Page 1  
4

Work Order ID: 57163



Parent Item: D2512

Parent Item Name: Basket Lid 205/350

Start Date: 24/03/2010

Required Date: 31/03/2010

Comments: Rev IPP:M 03.01.31 Added D2012-117 for D130-701-041 KJ/RF  
IPP Rev:N 06.04.05 Added level21 EC  
IPP Rev:O 08-08-29 revE as per dwg DD verified by:EC  
IPP Rev:P 08-09-24 plug holes prior to powder coating DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D2012-117 Manufactured No 100 Each 41.0000 2.0000



Clevis



N/A

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
WA	41	
31101	2	
52498	9	
55729	30	

\*\*\* ONLY APPLICABLE ON D130-701-041 -IF  
NOT USED, PLEASE MARK N/A \*\*\*

D2232-1 Manufactured No 100 Each 40.0000 2.0000



Basket Hinge



PD 10.08.23

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
WA	40	
48230	2	
55791	38	

D2327-1 Manufactured No 100 Each 27.0000 2.0000



Spacer Bushing



PD 10.08.23

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
WA	27	
52832	7	
54658	20	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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IPP Rev:N 06.04.05 Added level21 EC  
IPP Rev:O 08-08-29 revE as per dwg DD verified by:EC  
IPP Rev:P 08-09-24 plug holes prior to powder coating DD verified by:EC

Start Date: 24/03/2010

Required Date: 31/03/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D2506 Manufactured No 100 Each 6.0000 1.0000



Label Plate



B61174 ① 10/08/26

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

6

44275

1

55700

5

✓ D2581 Manufactured No 100 Each 35.0000 2.0000



Mounting Bracket



B60193 -> ② 11/10/23

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

35

46086

2

48428

1

50872

1

51120

2

51745

2

55918

27

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: Basket Lid 205/350

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 IPP Rev:N 06.04.05 Added level21 EC  
 IPP Rev:O 08-08-29 revE as per dwg DD verified by:EC  
 IPP Rev:P 08-09-24 plug holes prior to powder coating DD verified by:EC

Start Date: 24/03/2010

Required Date: 31/03/2010

Start Qty: 1.00

Required Qty: 1.00

D3166-3 Manufactured No 100 Each 16.8103 1.0000



Basket Hoop



SAD 10-08-17

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

WA

16.81031447

48429

5

52058

1.4474E-05

55697

5.8103

56426

6

M304EX0.75-16F

Purchased

No

100

sf

1,081.944

18.9474



Expanded Metal Flat SS



SAD 20-08-18

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

1081.944806

111956

0.000017

112147

9.4736E-06

112949

19.84438

113205

0.0093

113497

0.1449

113555

649.5873

113904

92.3589

114212

320

M115401

M115012

16.9475

2.000

March 24, 2010 8:54:09 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 4

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IPP Rev:N 06.04.05 Added level21 EC  
IPP Rev:O 08-08-29 revE as per dwg DD verified by:EC  
IPP Rev:P 08-09-24 plug holes prior to powder coating DD verified by:EC

Start Date: 24/03/2010

Required Date: 31/03/2010

Start Qty: 1.00

Required Qty: 1.00

M304TS0.750W.065

Purchased

No

100

f

638.1112 45.8741



304 SQ Tube .75x.75x.065W

SAD 10-08-17

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

WA

638.1111759

112398

0.0000047

113082

0.00419

113245

8.40038421

113683

0.30855

113836

0.000047

113956

29.398

114137

600

m115274

45.8742

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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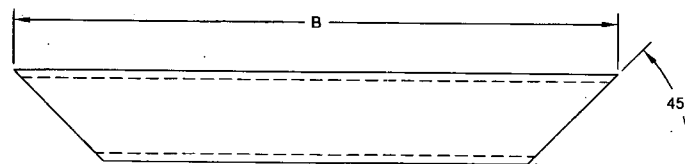
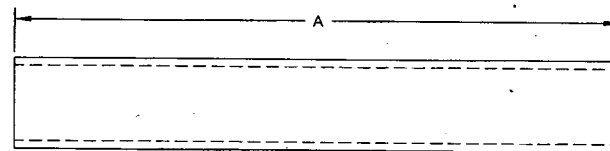
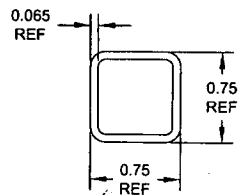
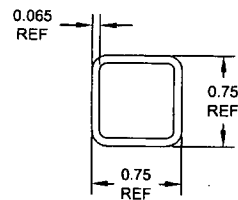
**NOTE:** Date & initial all entries



# **PARTS LIST FOR D2512 BASKET LID ASSEMBLY**

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 57143  
BS103-24



**RELEASED**  
08.06.17

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO 'B' FORMAT AND UPADTED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS. INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

## **D2512-1/-3/-5/-7 NOTES:**

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

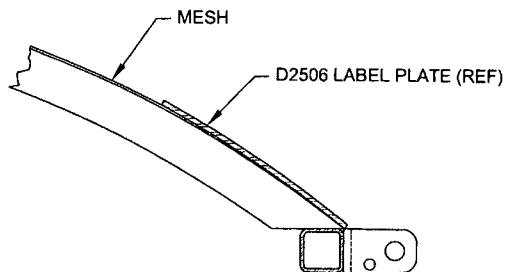
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**SECTION A-A<sub>B3-2</sub>**  
(ROTATED 90° CCW)

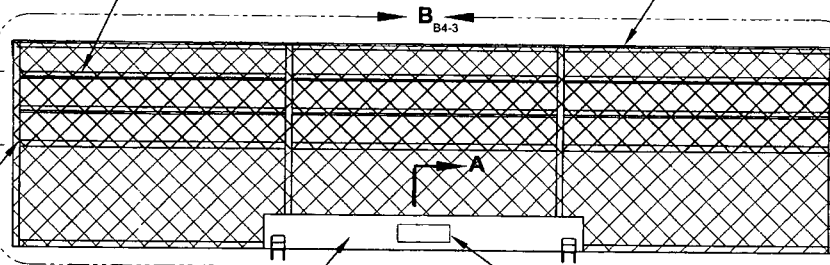


FINISH THIS SECTION ALONG  
ENTIRE LENGTH PER NOTE 3  
AFTER POWDER COAT.

TACK WELD MESH TO FRAME  
AT EVERY AVAILABLE LOCATION  
IN AREA TO BE ANTI-SKIDDED

SKIN OUTSIDE SURFACE OF LID WITH  
3/4-16F EXPANDED SS. TACK WELD  
EACH END STRAND TO FRAME

SEE DETAIL B FOR  
FRAME ASSEMBLY



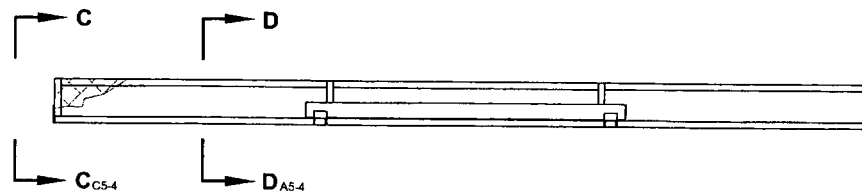
D2506 LABEL PLATE  
CENTER ON THE BASKET

REMOVE 2" X 6" SECTION  
OF MESH FROM BEHIND  
LABEL PLATE



**D2512 BASKET LID ASSEMBLY NOTES:**

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE  
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004



**RELEASED**  
05-05-21/11

DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

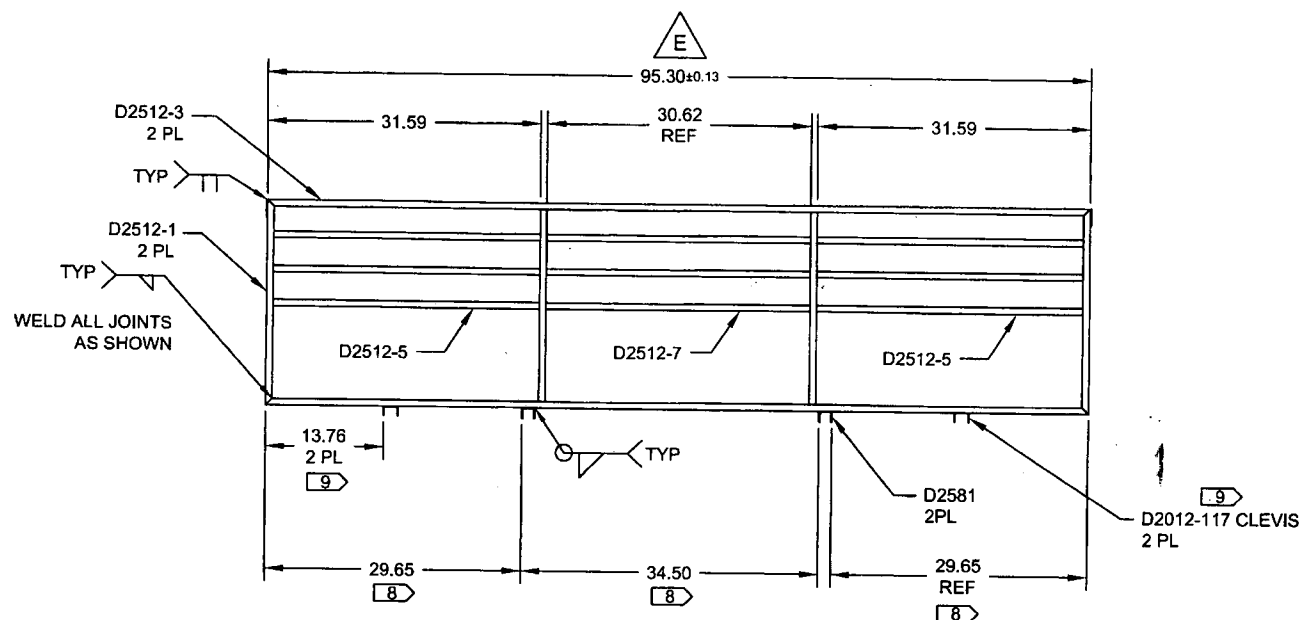
W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

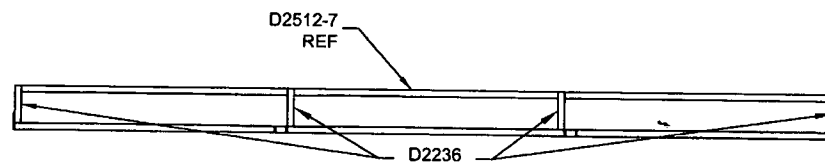
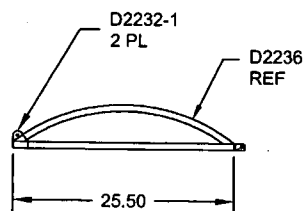
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



**DETAIL B** C3-2  
FRAMEWORK ONLY SHOWN FOR CLARITY



**NOTES:**

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY
- 9) FOR D130-701-041 ONLY

**RELEASED**  
08.06.17

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.	<i>JS</i>	D2512	SHEET 3 OF 4
APPROVED	<i>NO</i>	TITLE	SCALE
DE APPR.	<i>JA</i>	BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

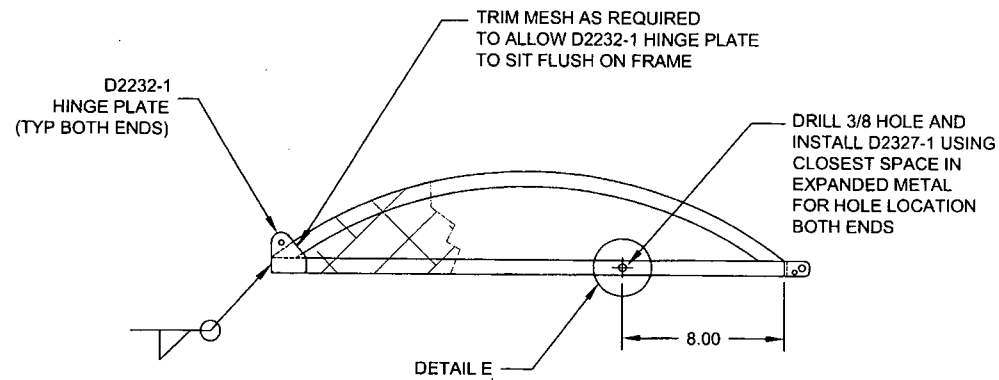
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

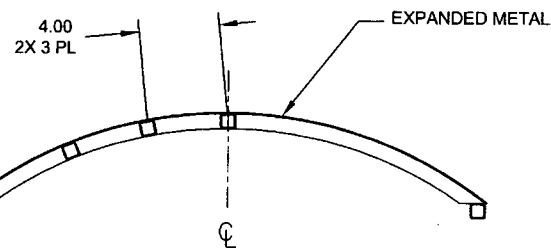
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

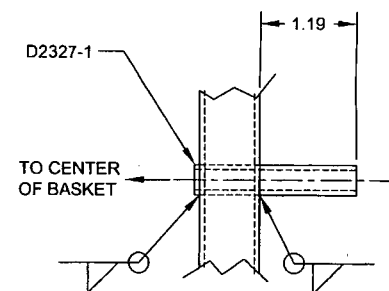
8 7 6 5 4 3 2 1



**VIEW C-C SIMILAR BOTH END RIBS** A5-2



**SECTION D-D SAME BOTH CENTER RIBS** A4-2



**DETAIL E** C6-4

**RELEASED**  
08.06.17

57163

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG APPR.		D2512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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8 7 6 5 4 3 2 1

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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